

Date: Wednesday, 2/15/2006 3:46:01 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 25828
Estimate Number : 10530
P.O. Number : N/A
This Issue : 2/15/2006 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : MACHINED PARTS
Previous Run : 25016
Written By : See comment below
Checked & Approved By : 06.02.16
Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ
Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Part Number : D2571
Drawing Number : D2571 REV DE
Project Number : N/A
Drawing Revision : DE
Material : N/A
Due Date : 3/15/2006
Qty: 10 Um: Each
15

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101007 7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
7075-T7351 8.25X7.75X2.5
Make from D6101-007 billet for D2571
Ensure that grain is along 7.75" length
Batch No: 8 24893 (15)

J.G 06/03/13 15

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No: 25828 Double check by: SN

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove sharp edges.

En / BG For J.G. 15

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2571 & D2572

En / BG For J.G. 15

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En / BG For J.G. 15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2571 PAR #: N/A Fault Category: Prod / MACHINING PARTS NCR: (Yes) No DQA: (D) Date: 06/03/23
 QA: N/C Closed: Date:

NCR: <u>25828</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/03/14	±	one (1) SADDLE (D2571) SCRAP Dim "w" Ranges from 0.106" to 0.116" (instead of 0.125") incorrect amount of shims used	<u>AE</u>	- SCRAP / destroy and Replace - Remove the shim and use correct correct amount.	<u>Er</u> 06/03/15	<u>2</u> 06/03/15	<u>18</u> 06/03/15	<u>2</u> 06/03/15

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 3:46:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 25828

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BG. 06.03.22

15

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

DC 06/03/22 (15)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/03/22 (15)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

DC 4/3/22 (15)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 478

DC 4/3/22 (15)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

WSP 06/03/23
W 06/03/23

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25828
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.746	1.746	1.749	1.748		
C	3.495	3.505		3.495	3.496	3.496	3.496		
D	1.745	1.755		1.746	1.746	1.750	1.750		
E	7.990	8.010		8.002	8.001	8.002	8.001		
F	0.490	0.510		0.506	0.501	0.509	0.508		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.500	0.498	0.498		
J	1.174	1.184		1.177	1.177	1.179	1.179		
K	0.558	0.578		0.566	0.566	0.571	0.570		
L	1.174	1.184		1.177	1.177	1.178	1.178		
M	1.490	1.500		1.493	1.494	1.498	1.499		
N	2.495	2.505		2.495	2.496	2.497	2.497		
O	3.869	3.879		3.871	3.872	3.874	3.874		
P	0.115	0.135		0.126	0.125	0.126	0.125		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.249	0.248	0.244	0.244		
S	0.115	0.135		0.126	0.127	0.130	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.241	0.242	0.236	0.235		
W	0.115	0.135		0.122	0.123	0.125	0.126		
X	0.308	0.313		0.316	0.316	0.316	0.316		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.361	0.361	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.630	0.629	0.625	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.244	0.255	0.254		
AE	1.375	1.395		1.387	1.386	1.387	1.386		
AF	0.115	0.135		0.130	0.130	0.130	0.13		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.241	0.241	0.245	0.245		
AI	2.000	2.020		2.007	2.000	2.000	2.000		
AJ	0.023	0.043		0.030	0.032	0.030	0.030		
Accept/Reject									

Measured by:	En / S.G.
Date:	06/03/16

Audited by:	BG
Date:	06.03.22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	25828
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

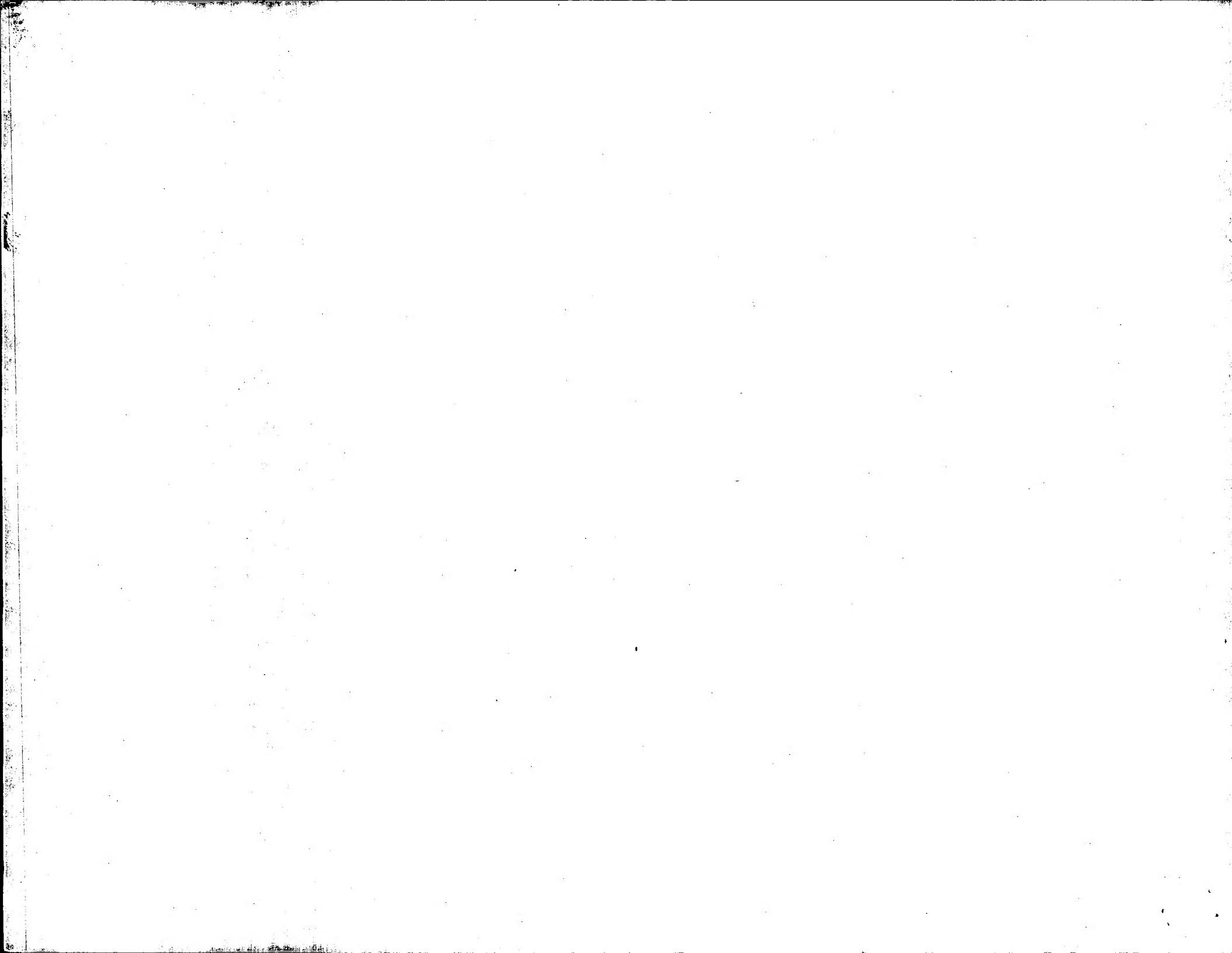
Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.747	1.747	1.745	1.745		
C	3.495	3.505		3.499	3.500	3.495	3.496		
D	1.745	1.755		1.747	1.747	1.745	1.745		
E	7.990	8.010		8.001	8.002	8.006	8.006		
F	0.490	0.510		0.501	0.500	0.499	0.492		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.501	0.498	0.500		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.568	0.568	0.564	0.565		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.490	1.500		1.499	1.499	1.494	1.493		
N	2.495	2.505		2.495	2.496	2.495	2.497		
O	3.869	3.879		3.872	3.872	3.872	3.871		
P	0.115	0.135		0.120	0.120	0.127	0.127		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.250	0.249	0.240	0.240		
S	0.115	0.135		0.130	0.130	0.120	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.240	0.240	0.235	0.236		
W	0.115	0.135		0.130	0.131	0.127	0.125		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.362	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.625	0.625	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.245	0.240	0.240		
AE	1.375	1.395		1.387	1.387	1.390	1.390		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.250	0.240	0.240		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	SGI
Date:	

Audited by:	SG
Date:	06.03.22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



DART AEROSPACE LTD	Work Order:	25828
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.746	1.746	1.746	1.745		
C	3.495	3.505		3.496	3.496	3.498	3.495		
D	1.745	1.755		1.746	1.746	1.746	1.745		
E	7.990	8.010		8.005	8.005	8.005	8.006		
F	0.490	0.510		0.492	0.493	0.494	0.497		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.500	0.500	0.501		
J	1.174	1.184		1.177	1.177	1.177	1.178		
K	0.558	0.578		0.565	0.564	0.568	0.566		
L	1.174	1.184		1.177	1.177	1.177	1.178		
M	1.490	1.500		1.493	1.493	1.494	1.496		
N	2.495	2.505		2.496	2.496	2.497	2.498		
O	3.869	3.879		3.873	3.871	3.871	3.872		
P	0.115	0.135		0.129	0.129	0.127	0.127		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.240	0.241	0.240	0.247		
S	0.115	0.135		0.126	0.129	0.126	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.237	0.240	0.240	0.243		
W	0.115	0.135		0.125	0.124	0.125	0.121		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.362	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.632	0.631	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.242	0.242	0.242	0.243		
AE	1.375	1.395		1.386	1.387	1.389	1.379		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.240	0.242	0.240	0.249		
AI	2.000	2.020		2.000	2.001	2.002	2.000		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	Ep
Date:	06/03/20

Audited by:	86
Date:	06.03.22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

Drawn by:	AER SPACE LTD	Work Order:	25828
Description:	Idle, Fwd Outboard	Part Number:	D2571
Inspection Drawing:	D2571 Rev. E		Page 1 of 1

Inspection dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim				Recorded Actual Dimensions				By	Date
	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.438	0.438	0.438			
B	1.745	1.755		1.746	1.745	1.745			
C	3.495	3.505		3.496	3.495	3.497			
D	1.745	1.755		1.746	1.745	1.747			
E	7.990	8.010		8.006	8.006	8.005			
F	0.490	0.510		0.492	0.493	0.493			
G	0.257	0.262	DT8683	0.257	0.257	0.257			
H	0.375	0.380	DT8684	0.375	0.375	0.375			
I	0.490	0.510		0.500	0.501	0.500			
J	1.174	1.184		1.177	1.178	1.177			
K	0.558	0.578		0.563	0.565	0.565			
L	1.174	1.184		1.177	1.178	1.177			
M	1.490	1.500		1.494	1.493	1.494			
N	2.495	2.505		2.495	2.497	2.497			
O	3.869	3.879		3.872	3.871	3.871			
P	0.115	0.135		0.125	0.128	0.125			
Q	0.115	0.135		0.130	0.130	0.130			
R	0.240	0.260		0.246	0.249	0.249			
S	0.115	0.135		0.124	0.123	0.123			
T	0.178	0.198		0.188	0.188	0.188			
U	2.940	2.980		2.960	2.960	2.960			
V	0.230	0.250		0.242	0.241	0.241			
W	0.115	0.135		0.121	0.120	0.120			
X	0.308	0.313		0.310	0.310	0.310			
Y	0.760	0.765		0.760	0.760	0.760			
Z	0.352	0.372		0.360	0.360	0.360			
AA	0.470	0.530		0.500	0.500	0.500			
AB	0.615	0.635		0.631	0.626	0.626			
AC	0.053	0.073		0.063	0.063	0.063			
AD	0.240	0.260		0.252	0.248	0.248			
AE	1.375	1.395		1.380	1.385	1.385			
AF	0.115	0.135		0.130	0.130	0.130			
AG	0.240	0.280		0.260	0.260	0.266			
AH	0.240	0.260		0.251	0.250	0.250			
AI	2.000	2.020		2.000	2.000	2.000			
AJ	0.023	0.043		0.030	0.030	0.030			
Accept/Reject									

Measured by: Ep
Date: 06/03/20

Audited by: BG
Date: 06.03.22




Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE PART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

 $\triangle E$

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		DRAWN BY PH
CHECKED 		APPROVED 
		
		DART AEROSPACE LTD. HARRISBURY, ONTARIO, CANADA
DATE 05.07.13		DRAWING NO. D2571
		TITLE OUTER FWD SADDLE
		REV. E SHEET 1 OF 1 SCALE 2:1

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DART AEROSPACE LTD

DETAIL C
SCALE 4:3

SECTION A-A

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WITHOUT NOTICE

WORK ORDER
NO. 25828